



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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4 Oct
D3137-3

Job Sheet 183229



Part No: D3137-3

Job Qty: 10 ea

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 10/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP Rev:A 02.05.29 New Issue NG IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC IPP
Rev c 08.07.03 ECN1207 EC verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/2/18	10/2/18	0.00	0.00	Start Up Machining-1		18/09/18
100	Bandsaw	10 pcs	10/2/18	10/2/18	0.00	0.12	Bandsaw1		
110	CNC Vertical Machining	10 pcs	10/2/18	10/2/18	0.08	2.34	HAAS1-3		
130	QC	10 pcs	10/2/18	10/2/18	0.00	0.00	QC8 Machining-1		18/10/01
140	Packaging	10 pcs	10/2/18	10/2/18	0.00	0.00	Packaging3-1	STOR 80	OCT 04 2018
150	QC21-SA	10 Ea	10/2/18	10/2/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks. Blank size: 1.250" x .750" x .950" long
Descriptions: 110 - 1-Machine as per Folio FA242 & Dwg D3137

DAG
21
9-09

OCT 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRLNB0.750X1.250	Delrin Bar	.7910 ft (.0791 ea)	90-Start up Operation	5068422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELRLNB0.750X1.250	1	63	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guide	0.175inches ± 0.010	0.185 0.165		
2	Guide	0.257inches + 0.005 - 0.000	0.262 0.257		
3	Guide	0.650inches ± 0.010	0.660 0.640		
4	Guide	100Degrees ± 0	100 100		
5	Guide	0.425inches ± 0.010	0.435 0.415		
6	Guide	0.550inches ± 0.010	0.560 0.540		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Plex 9/14/18 6:52 AM Dart.laj@unnesse.marié

7	Guide	1.100inches ± 0.010	1.110 1.090
8	Guide	0.470inches ± 0.010	0.480 0.460
9	Guide	0.850inches ± 0.010	0.860 0.840
10	Guide	0.143inches ± 0.010	0.153 0.133

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description W. _____	DISPOSITION	PROCESS Water Jet ☐ Eng. Coord. ☐ Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐ MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval DART AEROSPACE Part: D3137-3 Job No: 183229 Serial No/Batch: S114475 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/28/18 Container No: S114475 DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 622-6200 Email: sales@dartco.com www.dartaerospace.com
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Root Cause	FAULT CATEGORY				
<table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>	Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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OTHER : ☐					